

Date:
User:Tuesday, 4/29/2008 8:23:06 AM
David Duva:

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GROUND PLATE
Job Number	: 38859		
Estimate Number	: 13282		
P.O. Number	:	Part Number	: D37971
This Issue	: 4/29/2008 S.O. No. :	Drawing Number	: D3797 PRELIM
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 4/29/2008 Type : SMALL / MED FAB	Drawing Revision	: PRELIM
Previous Run	:	Material	:
Written By	: <u>AD 08/04/30</u>	Due Date	: 5/6/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A 08-04-25 new issue DD verified by:ec		

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE

Job Number:



PRELIMINARY ISSUE

Seq. #: Machine Or Operation: Description:

1.0 M6061T6S050 6061-T6 .050 Sheet



Comment: Qty.: 0.4797 sf(s)/Unit Total: 0.4797 sf(s)
6061T6 aluminium sheet .050" thick
(M6061T6S050)
Batch: 104186 IB 8-4-30

- PROTOTYPE P Pho →
PAPERWORK
FOR GLARE SHIELD
- CAN BE FILED
LAST PAGE

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3797
Dwg Rev: A IB 8-4-30
Prog Rev: A

①

2- Deburr if necessary IB 8-4-30

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ENGINEERING
APPROVAL08/04/30 08-05-06

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

N/A 08-05-06

Date: Tuesday, 4/29/2008 8:23:06 AM
User: David Duval

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GROUND PLATE

Job Number: 38859

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 0054.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

N/A CP 08-05-06

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A CP 08-05-06

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

give to David Duval

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08-05-13 Prototype

Job Completion



Change to
w/o #00235

U 08-05-09
PARTS ACCEPTABLE
TO D3797 Rev C
CP 08-09-06

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-776-011

Job #: 00235

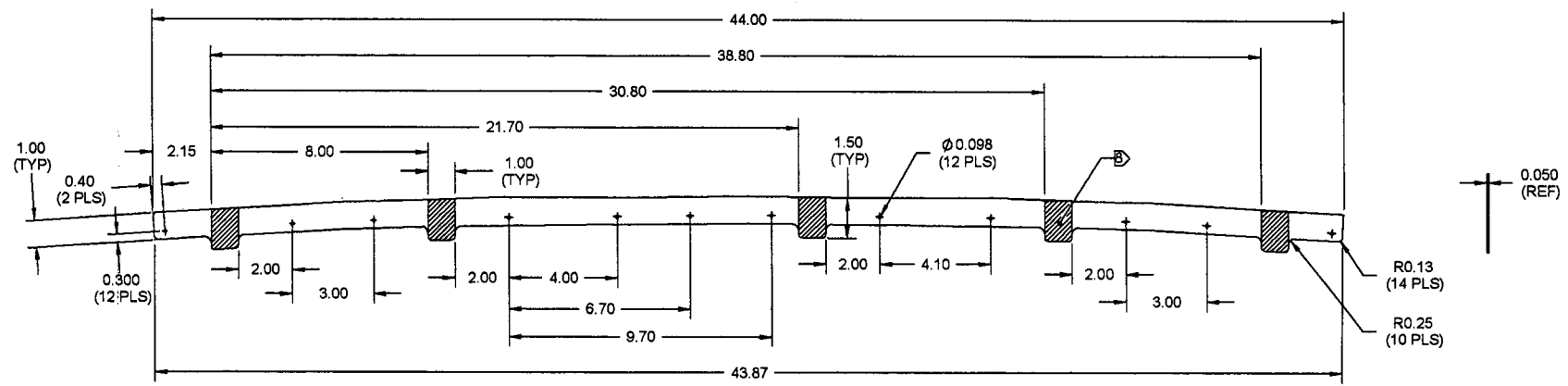
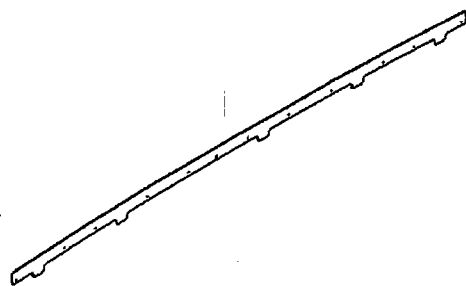
Date: 25-Apr-08

Product Name: B412 Glareshield

Requested By: MP for RF

Design Manager Approval: 

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3697-1	Tube	31/03/2008	y	09-May-08		
1	D3797-1	Ground Plate	31/03/2008	y	09-May-08		
1	D3697-3	Support Plate LH	31/03/2008	y	09-May-08		
1	D3697-4	Support Plate RH	31/03/2008	y	09-May-08		
1	D3698-1	Support Angle	31/03/2008	y	09-May-08		
1	D3690-1	Glareshield	31/03/2008	y	09-May-08		
1	D3697-041	Tube assy	31/03/2008	y	09-May-08		
1	D3699-041	Support Assy	31/03/2008	y	09-May-08		
1	D3699-042	Support Assy	31/03/2008	y	09-May-08		
1	D3690-041	Glareshield Assy	31/03/2008	y	09-May-08		



D3797-1 GROUND PLATE

PRELIMINARY ISSUE

08-04-25

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-250/8) ALUMINUM SHEET 0.050 THICK (REF. DART SPEC. MM5052H32S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.08 lbs
- 8) MASK HATCHED AREAS (5 PLS) ON BOTH SIDES OF THE PART PRIOR TO PAINTING

A NEW ISSUE		RF	08.04.24
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3797	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		GROUND PLATE	1:4
DATE	08.04.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 38859
Description: GROUND PLATE		Part Number: D3797-1
Inspection Dwg: D3797-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	x			
44.00	+/- .030	44.00	x			
43.87	+/- .030	43.87	x			
.300	+/- .010	.300	x			
1.00	+/- .030	1.009	x			
.40	+/- .030	.400	x			
8.00	+/- .030	8.00	x			
1.50	+/- .030	1.508	x			
1.00	+/- .030	.999	x			
2.00	+/- .030	2.013	x			
3.00	+/- .030	3.001	x			
4.00	+/- .030	3.998	x			
6.70	+/- .030	6.70	x			
9.70	+/- .030	9.70	x			
4.10	+/- .030	4.101	x			
21.70	+/- .030	21.70	x			
30.80	+/- .030	30.80	x			
38.80	+/- .030	38.80	x			
11.050	+/- .030	.048	x			






Measured by: IB	Audited by: J	Prototype Approval: P
Date: 8-4-30	Date: 08/04/30	Date: 08.05.06

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/08	2.0	welded in wrong orientation Didn't pay attention to Dwg. Final Dwg.		Scrap and Destroy. And replace qty 10 31 104/86	 08/05/08	 08/05/08		 08/05/08

NOTE: Date & initial all entries

Receiving Report

Date: 07/04/20

Batch No: 1104186

Supplier: Magna

Dart P/O: 3581

Packing Slip: Yes / No /
 Invoice: Yes / No /
 Receipt: Cash / Cr /

Release Note Attached: Yes / No / N/A /
 Waybill Attached: Yes / No / N/A /
 Shipment Complete: Yes / No / N/A /
 QC6 Inspection / N/A /
 Work Order / N/A /

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
	6061-T6 Alum	40	0	0	40	
	Flat 3/4x3					

Initials of receiver (if shipment OK) Level 12 PS

Production/Admin: 07/04/20
 Date
 Received/Costing R/P 4401-4417
 Initial GZ

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Sub-Total
 G.S.T.

468.00
 28.08

TOTAL →

496.08

FRAIS D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ DÙ.
 LE PRÉSENT CONTRAT SERA RÉGI PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME
 AYANT PRIS NAISSANCE DANS LE DISTRICT JUDICIAIRE DE MONTRÉAL.
 ADMINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.
 THE PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD
 BE CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.

ପ୍ରଶ୍ନାବଳୀ

Novelis

45295 / 45296 /
45297 / 278 / 279
111111

**NY/NJ
91352234-9**

Standard

~~7103-00-4-250/111 (1987)~~

Account ID	0000080983	Account Name	6061	Account Type	25	Account Number	BR-3345-2 110676 F3
Card No.		Cardholder Name	15 CARD	Cardholder Address		Cardholder City	
Cardholder Name	21.196 MB	Cardholder Address		Cardholder City		Cardholder State	
Cardholder Address		Cardholder City		Cardholder State		Cardholder Zip	
Cardholder City		Cardholder State		Cardholder Zip		Cardholder Phone	
Cardholder State		Cardholder Zip		Cardholder Phone		Cardholder Email	
Cardholder Zip		Cardholder Phone		Cardholder Email		Cardholder Fax	
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Cardholder Notifications		Cardholder Support		Cardholder Feedback		Cardholder Reviews	
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Cardholder Suppliers		Cardholder Manufacturers		Cardholder Wholesalers		Cardholder Retailers	
Cardholder Manufacturers		Cardholder Wholesalers		Cardholder Retailers		Cardholder Franchises	
Cardholder Wholesalers		Cardholder Retailers		Cardholder Franchises		Cardholder Licensees	
Cardholder Retailers		Cardholder Franchises		Cardholder Licensees		Cardholder Dealers	
Cardholder Franchises		Cardholder Licensees		Cardholder Dealers		Cardholder Agents	
Cardholder Licensees		Cardholder Dealers		Cardholder Agents		Cardholder Representatives	
Cardholder Dealers		Cardholder Agents		Cardholder Representatives		Cardholder Consultants	
Cardholder Agents		Cardholder Representatives		Cardholder Consultants		Cardholder Advisors	
Cardholder Representatives		Cardholder Consultants		Cardholder Advisors		Cardholder Experts	
Cardholder Consultants		Cardholder Advisors		Cardholder Experts		Cardholder Specialists	
Cardholder Advisors		Cardholder Experts		Cardholder Specialists		Cardholder Professionals	
Cardholder Experts		Cardholder Specialists		Cardholder Professionals		Cardholder Researchers	
Cardholder Specialists		Cardholder Professionals		Cardholder Researchers		Cardholder Analysts	
Cardholder Professionals		Cardholder Researchers		Cardholder Analysts		Cardholder Writers	
Cardholder Researchers		Cardholder Analysts		Cardholder Writers		Cardholder Editors	
Cardholder Analysts		Cardholder Writers		Cardholder Editors		Cardholder Publishers	
Cardholder Writers		Cardholder Editors		Cardholder Publishers		Cardholder Distributors	
Cardholder Editors		Cardholder Publishers		Cardholder Distributors		Cardholder Suppliers	
Cardholder Publishers		Cardholder Distributors		Cardholder Suppliers		Cardholder Manufacturers	
Cardholder Distributors		Cardholder Suppliers		Cardholder Manufacturers		Cardholder Wholesalers	
Cardholder Suppliers		Cardholder Manufacturers		Cardholder Wholesalers		Cardholder Retailers	
Cardholder Manufacturers		Cardholder Wholesalers		Cardholder Retailers		Cardholder Franchises	
Cardholder Wholesalers		Cardholder Retailers		Cardholder Franchises		Cardholder Licensees	
Cardholder Retailers		Cardholder Franchises		Cardholder Licensees		Cardholder Dealers	
Cardholder Franchises		Cardholder Licensees		Cardholder Dealers		Cardholder Agents	
Cardholder Licensees		Cardholder Dealers		Cardholder Agents		Cardholder Representatives	
Cardholder Dealers		Cardholder Agents		Cardholder Representatives		Cardholder Consultants	
Cardholder Agents		Cardholder Representatives		Cardholder Consultants		Cardholder Advisors	
Cardholder Representatives		Cardholder Consultants		Cardholder Advisors		Cardholder Experts	
Cardholder Consultants		Cardholder Advisors		Cardholder Experts		Cardholder Specialists	
Cardholder Advisors		Cardholder Experts		Cardholder Specialists		Cardholder Professionals	
Cardholder Experts		Cardholder Specialists		Cardholder Professionals		Cardholder Researchers	
Cardholder Specialists		Cardholder Professionals		Cardholder Researchers		Cardholder Analysts	
Cardholder Professionals		Cardholder Researchers					

Chemistries Assessing Interactions in Confined Spaces
Chemical compositions in percentages by weight

Case Number/Date of entry	Case No.	Age	Sex	Height	Weight	Temp	Pulse	Respiration	Blood Pressure	Remarks
100 059436	05/82225	0.52	0.34	0.26	0.09	0.85	0.03	0.01	0.02	
100 059435	05/81921	0.53	0.35	0.28	0.08	0.50	0.01	0.01	0.01	
100 059436	05/82227	0.52	0.34	0.26	0.08	0.85	0.03	0.01	0.02	
100 059436	05/82224	0.51	0.33	0.30	0.07	0.55	0.03	0.01	0.02	

Mechanisches Eigenverhalten Mechanical properties Caratteristiche meccaniche

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This certificate has been made out by me and that's why it isn't signed.

Necklesdorf
08-05

[illegible]

Wig, D. Wayne
Wilmington, Delaware
Phone: 336-2222

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